



Dart Aerospace Ltd.
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D3294-1
Job Sheet 199683

Part No: D3294-1 **Job Qty:** 12 pcs
Part Name: Bracket For Interior Window For -115

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 8/29/19 **Job Tracking No:**
Due Date: 9/24/19 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**
Note: DWG REV D IPP A 04.08.24 New Issue KJ/JLM IPP Rev:B Now On Waterjet 07-03-26 JLM IPP Rev:C 08-07-16 Redesign part DD verified by:EC IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		9/24/19	0.17	3.85	Waterjet - Flow		JRB
110	QC 2	12 pcs		9/24/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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CANADA
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Container No: S216746
Part: D3294-1
Job No: 199683
Serial No/Batch: S216746
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 09/24/19

PRIORITY

120 QC 8	12 pcs	9/24/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	SEP 2 5 2019 40
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - Brake NC - B4B	12 pcs	9/24/19	0.25 1.66	Small Fab - Brake - 1 - B4B	DAS 30 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	12 pcs	9/24/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	SEP 2 6 2019 40
				QC 5 - 61	9-89
				QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	12 pcs	9/24/19	0.00 0.92	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SEP 2 6 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	

					Handfinish - 1 - 6 - B4B						
					Handfinish - 1 - 7 - B4B						
					Handfinish - 1 - 8 - B4B						
					Handfinish - 1 - 9 - B4B						
					Handfinish - 1 - 10 - B4B						
					Handfinish - 1 - 11 - B4B						
					Handfinish - 1 - 12 - B4B						
					Handfinish - 1 - 13 - B4B						
					Handfinish - 1 - 14 - B4B						
					Handfinish - 1 - 15 - B4B						
					Handfinish - 1 - 16 - B4B						
					Handfinish - 1 - 17 - B4B						
					Handfinish - 1 - 18 - B4B						
					Handfinish - 1 - 19 - B4B						
					Handfinish - 1 - 20 - B4B						
					Handfinish - 1 - 21 - B4B						
					Handfinish - 1 - 22 - B4B						
					160 QC 7	12 pcs	9/24/19	0.00	0.00	QC 7 - 10	
										QC 7 - 13	
										QC 7 - 14	
										QC 7 - 15	
										QC 7 - 17	
QC 7 - 18											
QC 7 - 19											
QC 7 - 2											
QC 7 - 28											
QC 7 - 3											
QC 7 - 30											
QC 7 - 34											
QC 7 - 36											
QC 7 - 37											
QC 7 - 41											
QC 7 - 47											
QC 7 - 48											
QC 7 - 51											
QC 7 - 58	DAS 58 SEP 26 2019 9.00										
QC 7 - 59											
QC 7 - 60											
QC 7 - 9											
QC 7 - 68											
QC 7 - 50											
QC 7 - 67											
QC 7 - 40											
QC 7 - 24											
QC 7 - 43											
QC 7 - 61											
QC 7 - 81											
170 Small Fab - 2 - B4B	12 pcs	9/24/19	0.00	1.88	Small Fab - 1 - B4B	DAS 58 SEP 26 2019 9.00					
					Small Fab - 2 - B4B	58 9.00					
					Plex 8/29/19 10:28 AM Dart.lajeunesse.marie						

180 QC 5	12 pcs	9/24/19	0.00 0.00	Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS SEP 26 2019 68
				QC 5 - 9	9-89
190 Powdercoat - 4 Black Sand - B4B	12 pcs	9/24/19	0.00 0.53	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
200 QC 3	12 pcs	9/24/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	DAS SEP 27 2019 40
				QC 3 - 40	9-89
				QC 3 - 19	
				QC 3 - 43	
210 Packaging 3-1 - Stock - B4B	12 pcs ✓	9/24/19	0.00 0.00	QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	ST 435
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	

Fri 9-27-2019

Oscar

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	12 pcs	9/24/19	0.00 0.00	QC 21 - SA - 21	ST 435
				QC 21 - SA - 70	21
				QC 21 - SA - 53	SEP 27 2019

Part Op 100 - 1-Cut as per Dwg D3294 CUT File D3294-3 Dwg Rev: _____ Prog Rev: _____ *grain direction on a 45 deg as

Descriptions: per dwg** 2-Deburr if necessary

110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - 1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - 1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

180 - QC5- Inspect part completeness to step on W/O)

190 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) Start Time: 8:00 Oven Temperature: 320° Finish Time: 11:38 AM

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: _____)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	21,6000 sf (1.8 ea)	100-Waterjet - Flow - 1	S 216343 5194286
D3294-5	Doubler	12 pcs (1 ea)	170-Small Fab - 2 - B4B	
MS20470AD4-5	Rivet, Universal Head	180 Ea (15 ea)	170-Small Fab - 2 - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	22	90	0
170-Small Fab - 2 - B4B	D3294-5	12	20	0
	MS20470AD4-5	180	2,104	0

Part Specifications
Specifications could not be found.

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DART AEROSPACE LTD		Work Order:	199683
Description: Bracket Assembly		Part Number:	D3294-1
Inspection Dwg: D3294 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	✓		DC-02V	
Ø0.141	+0.005/-0.001	0.142	✓			
6.708	+/-0.010	6.710	✓		Tape	
1.118	+/-0.010	1.118	✓		DC-01V	
5.590	+/-0.010	5.592	✓			
1.118	+/-0.010	1.118				
13.563	+/-0.010	13.563				
1.043	+/-0.010	1.042				
0.625	+/-0.010	0.625				
0.325	+/-0.010	0.325				
0.300	+/-0.010	0.306				
0.400	+/-0.010	0.406				
6.000	+/-0.010	5.997				
1.000	+/-0.010	1.000				
17.124	+/-0.010	17.124				
16.13	+/-0.030	16.13				
7.27	+/-0.030	7.28				
11.97	+/-0.030	11.95				
8.37	+/-0.030	8.36				
20.05	+/-0.030	20.06				
12.98	+/-0.030	12.99				
14.59	+/-0.030	14.52				
11.66	+/-0.030	11.69				
0.080	+/-0.010	0.080				

Measured by: JRB	Audited by: DAS 40	Preliminary Approval:
Date: 9/24/19	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	

Job: _____		DISPOSITION			DEPARTMENT/PROCESS														
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐								
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QS1042)													
Description Work Order Deviation										Disposition									
Root Cause				FAULT CATEGORY															
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Completed By										Lead hand / Supervisor		QC / QA Coordinator							